

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013171**Date Inspected:** 18-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In Process Inspections**Bay 9**

This inspector witnessed layout and fitup of U- rib stiffeners for DP 3137-001, DP 3138-001, and DP 3145-001.

This inspector witnessed welding of U- rib stiffeners on deck panel u- ribs for DP 3145-001. The welder was identified as 059401. The WPS was identified as WPS- B-T-2133. ZPMC QC was identified as Mr. Chen Shigang.

This inspector witnessed welding of U- rib stiffeners on deck panel u- ribs for DP 3138-001. The welder was identified as 059373. The WPS was identified as WPS- B-T-2133. ZPMC QC was identified as Mr. Chen Shigang.

NDT Inspections

This inspector performed conventional ultrasonic testing, UT, on the following welds in the trial assembly yard:

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7AW to 7BW Edge plate to Edge Plate @ F9 after R1; OBE7C-001,002 7CE TO 7DE Side Plate on Cross beam side; SEGO37A-007 Bottom Plate to Side Plate on Cross beam side; SEG035A-031 Bottom Plate to Side Plate on Cross beam side; SEG037A-004 Bottom Plate to Side Plate on Cross beam side; OBE7C-004, OBE7C-005 Side Plate on Bike Path side; OBE7C-003 Bottom Plate; and SEG038A-004. This inspection was in conjunction with ABF UT technicians and to verify indications that were observed during their inspection. No additional indications were recorded by this inspector.

Unless otherwise noted, all work performed on this day appeared to comply with the applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
